

What is claimed is:

1. A laser welding method for supplying a filler wire to a welding object portion while projecting laser beam 2 to said welding object portion 5, wherein said filler wire 4 is supplied obliquely from forward or backward in a welding advance direction such that an angle between the supplying direction and beam axis of said laser beam 2 is less than  $45^\circ$ .
2. A laser welding method as claimed in claim 1 wherein said filler wire 4 is supplied from backward of said laser beam 2 with respect to the welding advance direction.
3. A laser welding method as claimed in claim 1 or 2 wherein said laser beam 2 is weaved in a direction substantially perpendicular to the welding advance direction.
4. A laser welding method as claimed in claim 3 wherein  $V_w/F \leq 2D/\sin \theta$  is established when an angle between said beam axis L and a supplying direction of the filler wire 4 is  $\theta$ , the diameter of key hole is D, supplying speed of said filler wire is  $V_w$  and weaving frequency of said laser beam 2 is F.